

Work Order ID 62877

Tuesday, October 12, 2010 1:04:37 PM

Page 1

Item ID: D117-762-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 10/12/2010 Start Qty: 1.00

Required Date: 10/22/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,
use bending aid DT9632
2- cut fwd end of tube as per dwg

Handwritten signature/initials

10-10-18

Handwritten mark

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	2							

NOTE: Date & initial all entries

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Item Name: Replacement Skidtube

Start Date: 10/12/2010 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end using DT8185								
	2-Deburr ends								
	3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***								
	4-Locate DT 8973 & Drill Ground wire hole on top of Tube.								
	5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.								
	6-Drill pilot holes for wearplates using DT8974								
	7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.								
	8- open ground wear holes to 0.391" as per section B-B								
	9-Open Aft Cap holes using .209" drill.								
	10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.								

1 — BE 10/10/10

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[illegible]

Page 3

Accept

**Setup Start**

Stop

1

Cust Item ID:

Abstract

Customer:

Run Start

Stop

[REDACTED]

**Insp.
Stamp**

0.00

Abstract

Skidtubes

0.00

Skidtubes

Memo

1-Weld fwd cap D2964 per dwg D3582 and QS/004

A/R AL ROD

Batch: *m1113851 m1115778*

2-Grind flush

0.00

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

Quality Control

0.00

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

(N)

BB
10/10/11

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

10-10-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

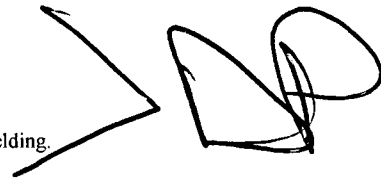


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open X-Bolt holes to finish size as per Dwg D3582, all sections								
	2-Counter Sink X-BOLT holes as per Dwg D3582								
	3-Deburr and blow out chips from inside of tube, prep. tube for welding.								
	4-Bond web as per Dwg D3582 & QSI 015 A/R 241 Sike Flex Batch: <u>M15778</u> Exp Date: <u>10/10/21</u>								
	5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B. A/R AL ROD Batch: <u>M15778</u>								
	6-Grind welds flush								
200 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC Quality Control	Memo	0.00							



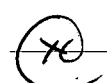
10-10-19

10/10/20



BE 10/10/21

DP 10-10-25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D117-762-041

Accept



Setup . Start



Revision ID:

Item Name: Remplacement Skidtube

Stop



Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
215 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115291 Memo START TIME 9:00 OVEN TEMPERATURE 320 FINISH TIME: 9:30	0.00 0.00							

PTO =>

1 Ø

BF 10-10-27

Ø

W/O: 62877

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/27	215	Reallocate (Touch-up) AS per PAR-09-043 <u>permanent change.</u>	HA	10/10/27	X1	/osun	/osun
			HA	10.11.17		/10.11.09	/10.11.09

 Part No: D117-762-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00

=> H 10/10/28

QC

Memo

0.00

Quality Control

240

HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

Install Wearplate & Ground Wire inserts as per Dwg D3582.

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: M115114
Exp Date: 11/10/11

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: M115114
Exp Date: 11/10/11

4-assemble o-ring as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M114189

5- Wing Walk as per Dwg D3043 and QSI 005 4.4 M115790

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Soluhi

(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D117-762-041

Location: PPP Rev:

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/11/11 SP 10

10/11/12

CHF
10-11-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item: D117-762-041

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Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 07.06.11 New Issue EC
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2962-150  3.540 Outer Tube, Extrut		Manufactured	No				Each	100.0000	1	1			
<div> <div> <u>Location</u> HALL 28672 59934 </div> <div> <u>Loc Qty</u> 100 27 73 </div> <div> <u>Loc Code</u> </div> </div>													
D2964  Cap		Manufactured	No			140	Each	19.0000	1	1			
<div> <div> <u>Location</u> LG 14101 </div> <div> <u>Loc Qty</u> 19 19 </div> <div> <u>Loc Code</u> </div> </div>													
D2971  Cross Bolt Spacer		Manufactured	No			190	Each	27.0000	1	1			
<div> <div> <u>Location</u> LG 44445 </div> <div> <u>Loc Qty</u> 27 27 </div> <div> <u>Loc Code</u> </div> </div>													
D3584-1  Web		Manufactured	No			190	Each	0.0000	1	1			
<div> <div> <u>Location</u> </div> <div> <u>Loc Qty</u> </div> <div> <u>Loc Code</u> </div> </div>													

① DP 10-10-18

✓ BE 10-10-19

✓ BE 10/10/21

1 BB 10/10/20

B62884

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00


Required Qty: 1.00

D2973 Manufactured No 190 Each 162.0000 2 2

 Cross Bolt Spacer


Location Loc Qty Loc Code

LG 162
 14636 162

D3662-3 Manufactured No 190 Each 27.0000 1 1

 Crossbolt Spacer


Location Loc Qty Loc Code

LG 27
 44456 27

D3662-1 Manufactured No 190 Each 19.0000 3 3

 Crossbolt Spacer

Location Loc Qty Loc Code

LG 19
 55328 19

ALS4-1032-130 Purchased No 240 Each 1,047.000 36 36

 Insert

Location Loc Qty Loc Code

PKG11 998
 114723 998
 ST282 10
 110511 10
 ST381 39
 114654 39

M115911

x36

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-428-165

Purchased

No

240

Each

107.0000

2

2



Inserts



10/10/28

Location

Loc Qty

Loc Code

FP

7

6989

7

ST282

100

114172

100

D2965

Manufactured

No

250

Each

42.0000

1

1



Cap, 105 Skidtube



10/10/28

Location

Loc Qty

Loc Code

FP4

42

52057

42

D3508-3

Manufactured

No

250

Each

2.0000

1

1



Wearplate



10/10/28

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

1

55339

1

D3508-9

Manufactured

No

250

Each

4.0000

1

1



Wearplate



10/10/28

Location

Loc Qty

Loc Code

FP21

4

54580

4

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Page 3

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Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010



Required Date: 10/22/2010

Start Qty: 1.00



Required Qty: 1.00

D3558-3	Manufactured	No	250	Each	13.0000	1	1
							<u>yl 10/10/28</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	13	
42253	1	
<u>55468</u>	12	<u>yl</u>

D3558-9	Manufactured	No	250	Each	18.0000	1	1
							<u>yl 10/10/28</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	18	
<u>50928</u>	4	<u>yl</u>
55469	14	

D3558-11	Manufactured	No	250	Each	3.0000	1	1
							<u>yl 10/10/28</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	3	
<u>42254</u>	3	<u>yl</u>

D3558-13	Manufactured	No	250	Each	35.0000	1	1
							<u>yl 10/10/28</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	35	
55467	1	
<u>59558</u>	34	<u>yl</u>

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Shop Packet Print

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Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010



Start Qty: 1.00

Required Qty: 1.00

D3508-11	Manufactured	No	250	Each	12.0000	1	1
							<u>21</u> 10/10/24
Wearplate							



Location Loc Qty Loc Code

FP16	12	
<u>54644</u>	12	

D3508-13	Manufactured	No	250	Each	3.0000	1	1
							<u>x1</u> <u>21</u> 10/10/24
Wearplate							



Location Loc Qty Loc Code

FP	3	
<u>54645</u>	3	

D3492-051	Manufactured	No	250	Each	54.0000	2	2
							<u>x1</u> <u>21</u> 10/10/24
Plug Assembly							



Location Loc Qty Loc Code

FP013	54	
44633	4	
<u>55622</u>	50	

D3492-049	Manufactured	No	250	Each	29.0000	2	2
							<u>x2</u> <u>21</u> 10/10/24
Plug Assembly							

Location Loc Qty Loc Code

FP011	29	
<u>55621</u>	29	

D3492-053	Manufactured	No	250	Each	19.0000	6	6
							<u>x2</u> <u>21</u>
Plug Assembly							

Location Loc Qty Loc Code

FP	19	
<u>54641</u>	19	

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Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 62877

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased

No

250

Each

0.0000

2

2



Washer

AN3C4A

Purchased

No

250

Each

1,511.000

28

28



BOLT

M114348



x2 28 10/12/2010



28 10/10/2010

Location

Loc Qty

Loc Code

ST245

20

110139

20

ST303

3

115438

3

ST350

1488

114108

14

114416

12

114523

2

115300

460

115589

1000

x28

AN3CSA

Purchased

No

250

Each

1,169.000

2

2



Bolt



28 10/10/2010

Location

Loc Qty

Loc Code

ST350

1159

114330

11

115015

16

115371

100

115422

100

115594

432

115835

500

ST351

10

113121

10

x2

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 1:04:41 PM

Page 7

Work Order ID: 62877

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased

No

250

Each

223.0000

2

2



Washer



10/12/25

Location

Loc Qty

Loc Code

ST346

223

106785

2

110153

221

AN960C10L NAS1149C0332 Purchased

No

250

Each

29.0000

28

28



washer



M115832

x28 10/10/25

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN4-4A Purchased

No

250

Each

186.0000

2

2



Bolt



x20

10/10/24

Location

Loc Qty

Loc Code

ST356

183

114615

183

ST361

3

108138

2

111295

1

NAS1611-012 Purchased

No

250

Each

110.0000

6

6



O-RING



10/10/24

Location

Loc Qty

Loc Code

FP

110

108673

9

113845

101

x3

x3

Tuesday, October 12, 2010 1:04:41 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Tuesday, October 12, 2010 1:04:41 PM

Work Order ID: 62877

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-015

Purchased

No

250

Each

25.0000

2

2



O-RING



10/10/2010

Location

Loc Qty

Loc Code

FP

25

107178

5

115101

20

X2

NAS1611-016

Purchased

No

250

Each

109.0000

2

2



O-RING



10/10/2010

Location

Loc Qty

Loc Code

FP

109

107178

9

112492

50

113524

50

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

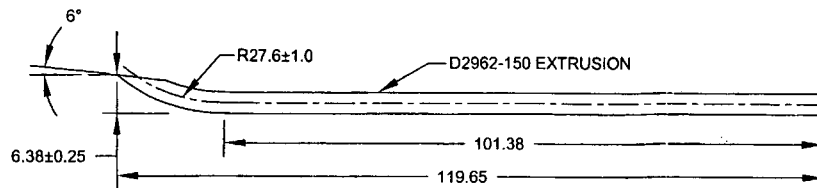
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

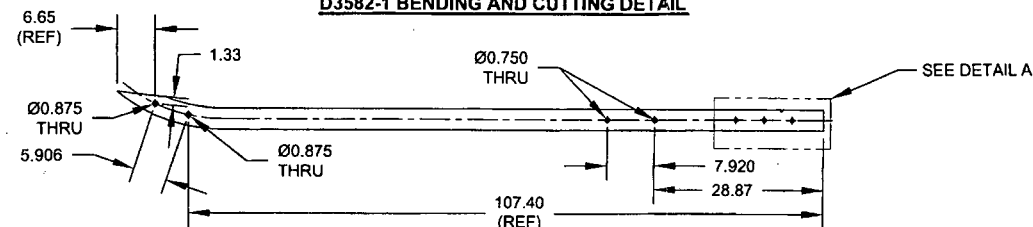
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

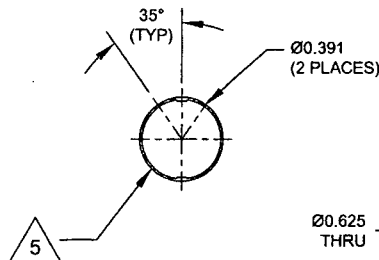
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



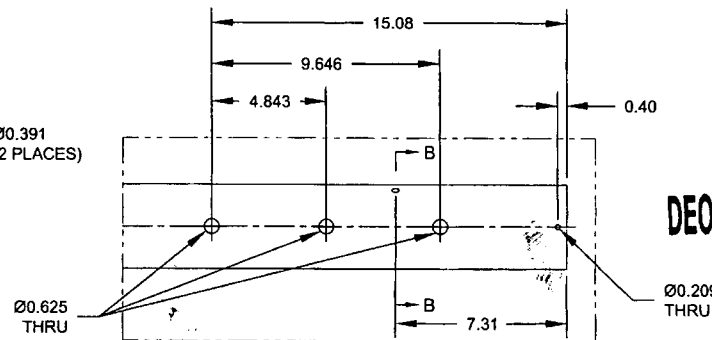
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5



DETAIL A
SCALE 1:5

RELEASED
07.11.22

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.06.08		

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D3582
TITLE BK 117 SKIDTUBE ASSEMBLY
REV. A
SHEET 1 OF 2
SCALE 1:20
COPYRIGHT © 2007 BY DART AEROSPACE USA, INC
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07871
2/10/10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

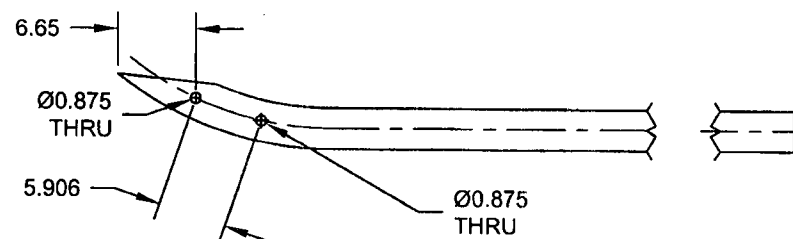
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

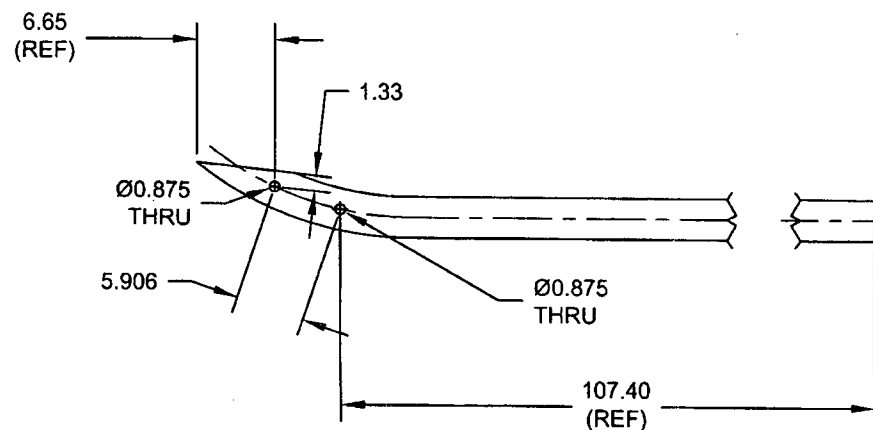
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



who 62877
RELEASED
09/04/22 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54161
Part number: D17-762-041
Description: 17 sk.d tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 09.12.10

Welder Barclay Elliott Date of Test Coupon 09/12/10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld